

Work Order ID 70819

Wednesday, June 15, 2011 2:27:34 PM



Page 1

Item ID:	D3463-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	End Cap					
Start Date:	6/15/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	6/22/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	6/15/11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3463	Rev B

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
304.063	1-Cut as per Dwg D3463 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Debur if necessary								

11-6-11

(36)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

11-6-11

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

8/10/11

counts
(736)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70819

Page 2

Wednesday, June 15, 2011 2:27:34 PM

Item ID: D3463-5

Accept



Setup Start



Revision ID:

Stop



Item Name: End Cap

Start Date: 6/15/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

*(36)**11/6/23*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/6/23**MF**11-06-23*

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Picklist Print

Wednesday, June 15, 2011 2:27:41 PM

Page 1

Work Order ID: 70819

Parent Item: D3463-5

Parent Item Name: End Cap





Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV. A 05.11.18 NEW ISSUE EC
IPP Rev:B Now on Waterjet 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	69.7000	0.014 	0.176842	1		
											PB11-6-27		
304/316 Sheet .063													

Location

Loc Qty

Loc Code

MAT020

69.7

117275

2.3

117653

67.4

117653

36

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SHOP COPY

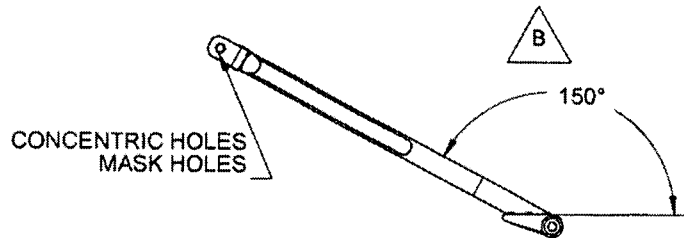
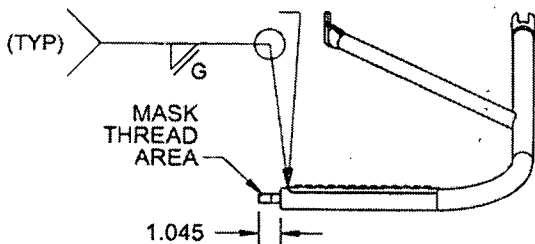


RETURN TO
ENGINEERING
ED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 70-819
05-11-06-15

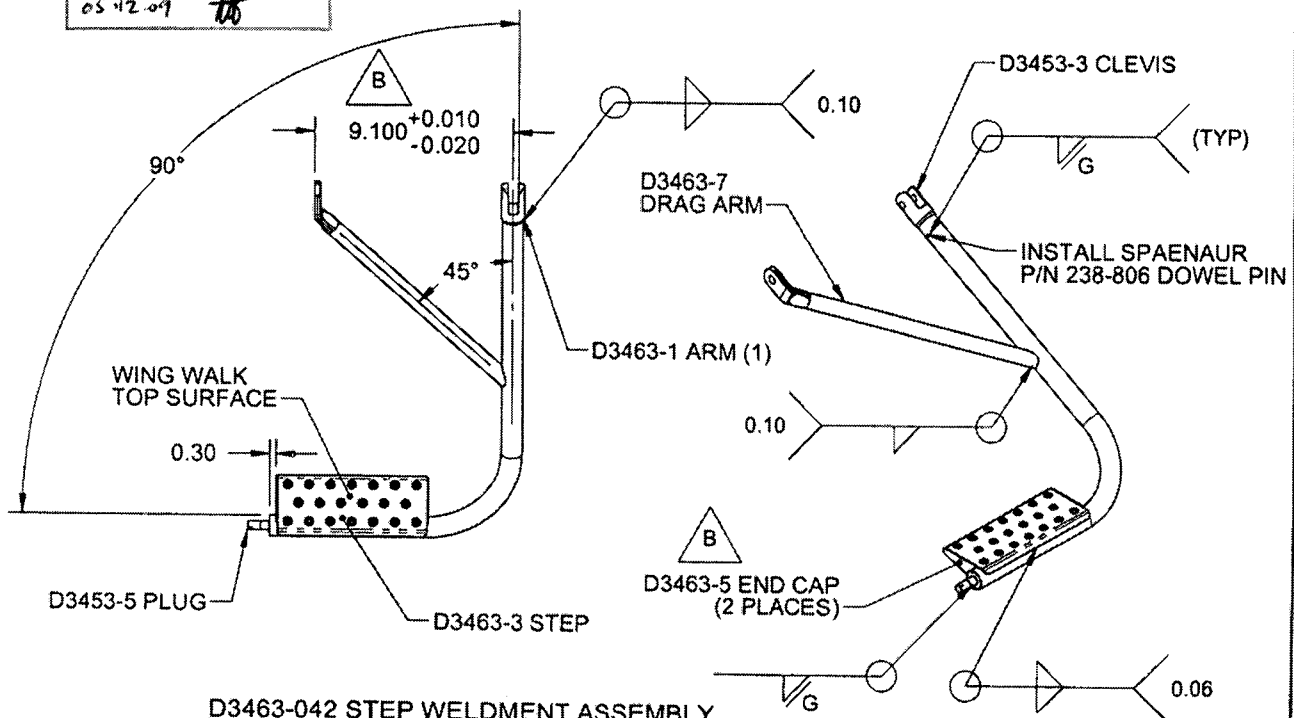
INSTALL P/N 238-806
DOWEL PIN

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



RELEASED

05-12-09 th



D3463-042 STEP WELDMENT ASSEMBLY
D3463-041 OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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NOTE: Date & initial all entries

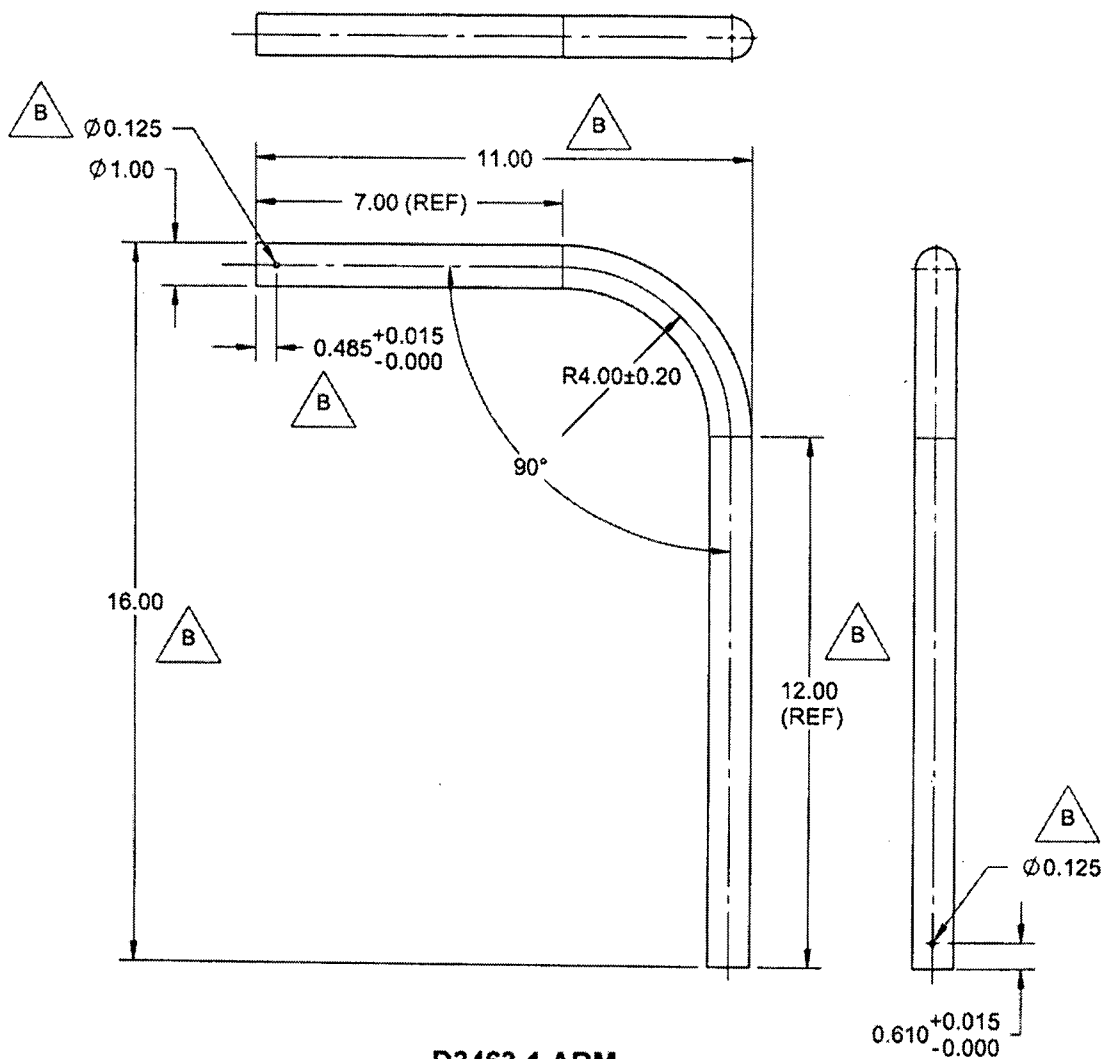


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09 *[Signature]*

ULO 70819



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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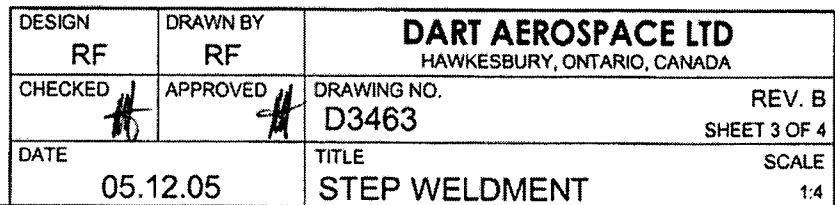
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



05.12.09

w/o 70 819



1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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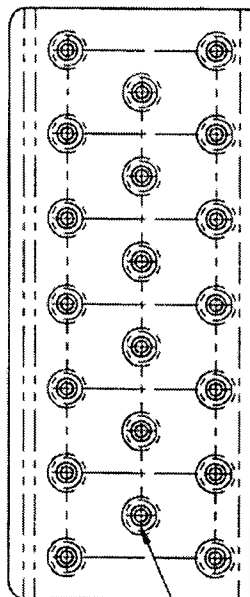


wlo 70819

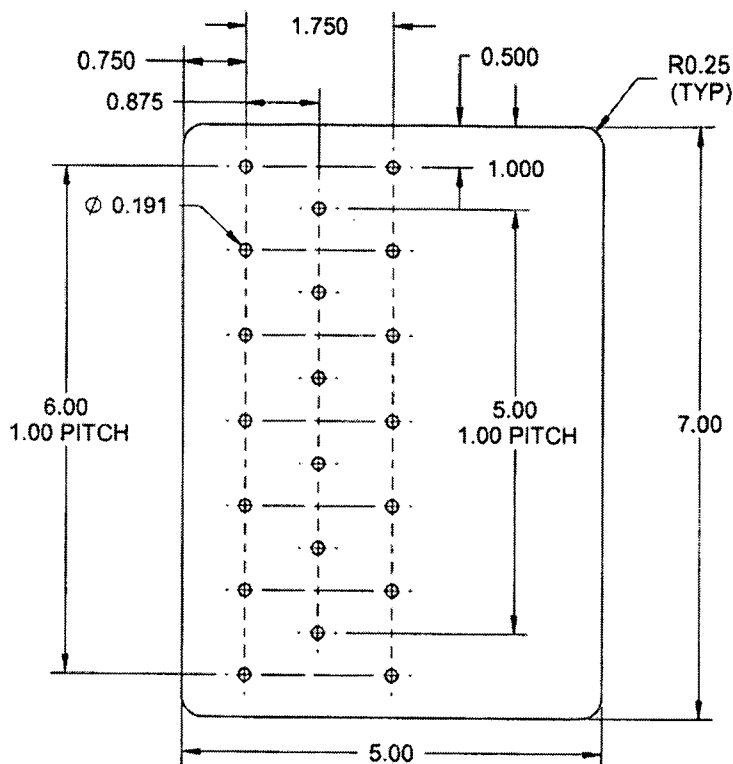
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED #	APPROVED #	DRAWING NO. D3463	SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

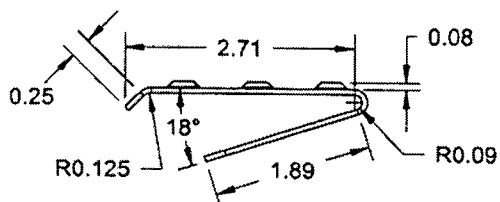
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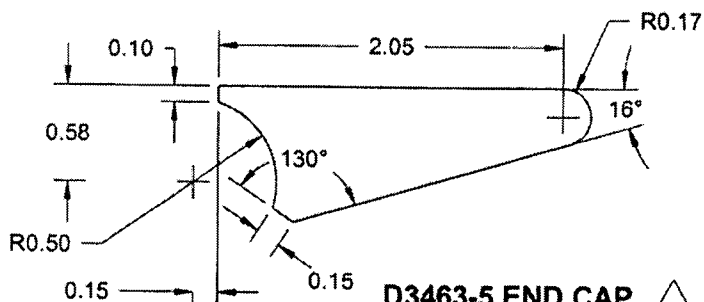
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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